



AMENDMENTS TO CLAIMS

Claim 1 (original): An attachment system for an article of manufacture, comprising:
a first member having a first flange providing a first attachment surface;
a second member having a second flange providing a second attachment surface, the second surface opposing the first surface, at least one of the first member and second member being a panel; and
a structural adhesive material adhered to the first surface and the second surface, the structural adhesive material having a tensile strength of at least 12 MPa.

Claim 2 (canceled)

Claim 3 (original): An attachment system as in claim 1 wherein a layer of primer and a layer of paint are disposed directly over the adhesive material concealing the adhesive material from a surrounding environment and providing a Class A or a Class B finish.

Claim 4 (canceled)

Claim 5 (canceled)

Claim 6 (original): An attachment system as in claim 3 wherein the structural adhesive material provides substantially the only attachment between the first surface and the second surface.

Claim 7 (canceled)

Claim 8 (original): An attachment system as in claim 3 wherein the structural adhesive material is applied to at least one of the first surface and the second surface with a mini-applicator.

Claim 9 (original): An attachment system as in claim 8 wherein the mini-applicator includes an extruder.

Claims 10-12 (canceled)

Claim 13 (original): An attachment system as in claim 3 wherein the adhesive material is formed from a heat activatable material that expands at a temperature encountered during at least one of an automotive e-coat and an automotive painting operation.

Claims 14-21 (canceled)

Claim 22 (new): An attachment system as in claim 1 wherein the first member or the second member is a roof panel of an automotive vehicle.

Claim 23 (new): An attachment system as in claim 22 wherein the first member or the second member is a side panel of an automotive vehicle.

Claim 24 (new): An attachment system as in claim 1 wherein the first member or the second member is a side panel of an automotive vehicle.

Claim 25 (new): An attachment system as in claim 1 wherein the first member is attached to the second member with less than 10 welds.

Claim 26 (new): An attachment system as in claim 1 wherein the first member is attached to the second member with less than 5 welds.

Claim 27 (new): An attachment system for an automotive vehicle, comprising:
a roof panel of the automotive vehicle, the roof panel having a flange extending at an angle from the roof panel, the flange providing an attachment surface;

a side body panel of the automotive vehicle, the side body panel having a flange extending at an angle from the side body panel, the flange of the side panel also providing an attachment surface; and

a structural adhesive material adhered to the attachment surface of the roof panel and the attachment surface of the side panel;

wherein the roof panel is attached to the side body panel with less than 20 welds; and

wherein a layer of primer, a layer of paint or both are disposed directly over the adhesive material.

Claim 28 (new): An attachment system as in claim 27 wherein the roof panel is attached to the side panel with less than 10 welds.

Claim 29 (new): An attachment system as in claim 27 wherein the roof panel is attached to the side panel with less than 5 welds.

Claim 30 (new): An attachment system as in claim 27 wherein the structural adhesive material has a tensile strength of at least 12 MPa.

Claim 31 (new): An attachment system as in claim 27 wherein the layer of primer, the layer of paint or both conceal the adhesive material from a surrounding environment and provide a Class A or a Class B finish.

Claim 32 (new): An attachment system as in claim 27 wherein the structural adhesive material provides substantially the only attachment between the attachment surface of the flange of the roof panel and the attachment surface of the flange of the side panel.

Claim 33 (new): An attachment system as in claim 27 wherein the structural adhesive material provides attachment between the roof panel and the body panel without the assistance of any welds.

Claim 34 (new): An attachment system as in claim 27 wherein the adhesive material extends substantially continuously along the attachment surface of the roof panel.

Claim 35 (new): An attachment system as in claim 27 wherein the adhesive material is formed from a heat activatable material that expands at a temperature encountered during at least one of an automotive e-coat and an automotive painting operation.

Claim 36 (new): An attachment system as in claim 27 wherein the flange of the roof panel extends downwardly at an angle relative to the roof panel.

Claim 37 (new): An attachment system as in claim 27 wherein the flange of the side body panel extends downwardly at an angle from the side body panel.

Claim 38 (new): An attachment system for an automotive vehicle, comprising:

- a roof panel of the automotive vehicle, the roof panel having a first flange extending at an angle from the roof panel, the first flange of the roof panel providing an attachment surface, the first flange of the roof panel extending downwardly at an angle relative to the roof panel;
- a side body panel of the automotive vehicle, the side body panel having a first flange extending at an angle from the side body panel, the first flange of the side panel also providing an attachment surface, the first flange of the side panel extending downwardly, the body panel having a second flange extending from the first flange of the side panel; and
- a structural adhesive material adhered to the attachment surface of the roof panel and the attachment surface of the side panel, the structural adhesive material being an epoxy-based structural foam, the structural adhesive material having a tensile strength of at least 12 MPa;

wherein the roof panel is attached to the side body panel with less than 10 welds;

wherein a layer of primer, a layer of paint or both are disposed directly over the adhesive material concealing the adhesive material from a surrounding environment and providing a Class A or a Class B finish;

wherein the adhesive material extends substantially continuously along the attachment surface of the first flange of the roof panel; and

wherein the adhesive material is formed from a heat activatable material that expands at a temperature encountered during at least one of an automotive e-coat and an automotive painting operation.